

Date: Monday, 05/05/2009 2:33:33 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BUSHING
Job Number : 39058
Estimate Number : 10518
P.O. Number :
This Issue : 05/05/2008 S.O. No. :
Prsht Rev. : NC Part Number : D28063
First Issue : / / Type : MACHINED PARTS Drawing Number : D2806 REV A
Previous Run : 36534 Project Number : N/A
Drawing Revision : A
Material :
Due Date : 12/05/2008 Qty: 20 Um: Each
Written By : 08.05.05
Checked & Approved By :
Comment : Est:B 05.03.11 Part now turned KJ/JLM
Est Rev:C Now on Doosan Lathe JLM Verified By:EC

Additional Product

Job Number:

Seq. # Machine Or Operation Description:

1.0 M6061T6H1000 6061-T6 1" Hex Bar

Comment: Qty: 0.0962 f(s)/Unit Total: 0.9618 f(s)
6061 T6 Hex Bar 1.0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar
(M6061T6H1.000) Batch: M17029 20 08/05/09

Doosan Lathe

1- Turn as per Folio FA105 Rev. A & Dwg D2806 Rev. A

2-Deburr per dwg D2806

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

Acid etch and Alodine as per QSI 005 4.1

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Drawing Name: BUSHING

Job Number: 39058

Part Number: D28063

Job Number:



Seq. #:

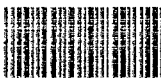
Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



20x

Comment: INSPECT ALODINE

8/3/13

SP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



20x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 48

8/5/13

SP

8.0

QC21

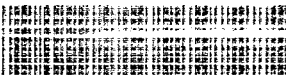
FINAL INSPECTION/W/O RELEASE



08/05/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



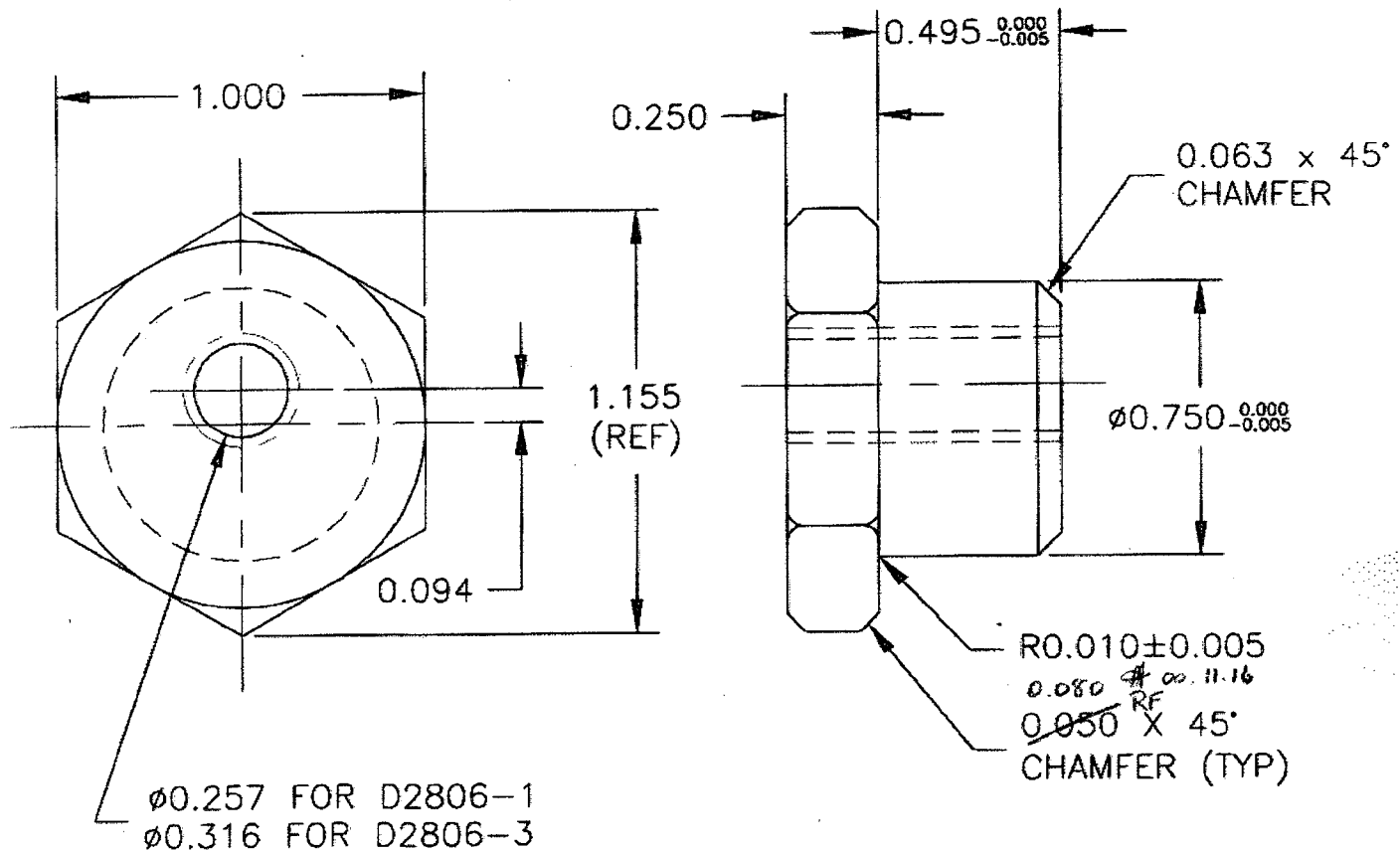
MF 08-05-13



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2806	REV. A SHEET 1 OF 1
DATE 00.11.08		TITLE BUSHING	SCALE 2:1
A	00.11.08	NEW ISSUE	

RELEASED
00.11.13 #

w/o 39050



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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